

WK 5/35

SPLIT

DART AEROSPACE LTD	Work Order:	23978
Description: Wearpad	Part Number:	D2648-3
Dwg: D2648 Rev. D	Qty:	400
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller RF 02.05.12 Dwg not required	RF	05.08.08	400
2	PG	Issue P/O: 200 8447 Email or ship DXF file to vendor Make per Drawing D2648-1 Material release note required	U	05.08.10	400
3	RG	Receive and Inspect for transit damage Ensure the material release note attached	CL	05/08/25	400
4	QC6	Inspect dimensions	MA	05/08/25	400
5	GA	Deburr if necessary			
6	GB	Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326 and identify as D2648-3	SB	05/09/01	401
7	WS	Weld as per Dwg D2648 using Jig DT 8210 Qty Description Batch A/R 7560 Hardcoat 1717914			192
8	WS	Remove any weld that penetrated through Wearpad if necessary	CPL	05/09/16	192
9	QC9	Inspect weld	MA	05/09/27	192
10	QC5	Inspect work to Step 9	MA	05/09/27	192
11	FP	Powder Coat Grey (RAL-7012) (Ref. 4.3.5.5) per QSI 005 4.3	KL	05 10 20	192
12	QC3	Inspect Powder Coat	MA	05 10 20	192
13	FP	Identify and Stock	MA	05 10 21	192
14	AC	Cost / part 6.05	SVC	05-10-24	192
15	DC	Close W/O 5.93 Inspect Level 21	RF	05/10/24	192

Rev	Date	Change	Revised By	Approved
A	97.12.04			
B	99.04.09	Re-format	DM	
C	00.06.22	Removed P/O for powder coat	EC	
D	00.11.15	Removed Bending	EC	
E	02.09.18	Re-format; Incorporated D2648-1	KJ RF	

RELEASED
02/09/19 RF



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8999 / 375 8111 Auckland
(09) 235 8069 / 235 3535 Waiuku
Fax: (09) 375 8959

TEST CERTIFICATE

Ref: 507E21768

CUSTOMER	Wilkinson	P50128DI003	SPECIFICATION	ASTMA1008 CS Type A	CERTIFICATE No	TC109561
CUSTOMER O/N	90-21N-540		PRODUCT	CRA WIDE COIL	PAGE	1 of 1
MILL O/N	471159		DIMENSIONS	0.055" x 48" x Coil	DATE	23 April 2005

PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT																MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)						
		C	SI	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE()	BEND	YIELD	T.S	%ELONG	HARDNESS	r	LENGTH
		x100			x1000													x10000	x100	180°			G.L.=	HRB
R9-457097-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1562
R9-457098-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1483
R9-457099-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1562
R9-457100-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1496
R9-457101-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				47		1562
R9-457102-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				47		1555

YIELD	GAUGE LENGTH (G.L.)		PLASTIC STRAIN RATIO (r)		IMPACT TEST	(C)=5mm x 5mm	CARBON EQUIVALENT VALUE (CE)	
(A)=0.2% PROOF STRESS	(A)=200mm	(C)=80mm	(E)=2"	(A)=r0	(C)=r45	(D)=2.5mm x 10mm	(A)=C+Mn/6	(C)=C+Mn/6+Si/24
(B)=LOWER YIELD STRESS	(B)=50mm	(D)=5.65 ±0.50	(F)=8"	(B)=r90	(D)=(r0+r90+2r45)/4	(E)=5mm x 10mm	(B)=C+Mn/6+(C+V+Mo)/5+(Cu+Ni)/15	(D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

Satish Misra
QC METALLURGIST

16 ga crms

